









Work Order ID 68858

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Thursday, April 21, 2011 12:42:10 PM

Item ID: D3608-1 Accept  Setup Start 
Revision ID: Stop 
Item Name: Lower Doubler
Start Date: 4/21/2011 Start Qty: 4.00  Cust Item ID:
Required Date: 5/6/2011 Req'd Qty: 4.00  Customer:
Reference:


Approvals: Process Plan:  Date: 4/21/2011 Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3608	C								

100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3608								
3041 .046	Dwg Rev: <u>C</u>								
	Prog Rev: <u>L</u>								
	2-Deburr if necessary								

B11-4-05 (5)

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
									
QC	Memo	0.00							
Quality Control									

B11-4-05

120	QC8- Inspect parts - second check	0.00							
									
QC	Memo	0.00							
Quality Control									

(X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68858

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Item ID: D3608-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Lower Doubler

Start Date: 4/21/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 5/6/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 	Identify as per dwg & Stock Location: <u>175</u>	0.00							
Packaging Packaging	Memo	0.00				11/4/26		50	
160 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							11/4/27 MF 11-04-26

W/O:		WORK ORDER CHANGES					
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Picklist Print

Thursday, April 21, 2011 12:42:07 PM

Page 1

Work Order ID: 68858



Parent Item: D3608-1



Parent Item Name: Lower Doubler



Start Date: 4/21/2011

Required Date: 5/6/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-03-26 JLM
IPP Rev:B 08-10-15 preliminary issue DD verified by:EC
IPP Rev:C 08-12-11 rev.A as per dwg DD verified by:EC IPP
Rev:D 10.02.16 rev.B as per dwg DD verified by:EC IPP Rev:E
10.11.17 as per PC1 dwg DD verified by:EC IPP Rev:F 10.11.29 as
per revC dwg DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA  304/316 .040 Sheet		Purchased	No			100	sf	4.2000	0.7392	3.112421	 BII-4-25		
						<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>			
						MAT020		4.2					
						116623		4.2		116623			

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DART AEROSPACE LTD		Work Order:	68858
Description: Lower Doubler		Part Number:	D3608-1
Inspection Dwg: D3608	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	.105	X		V	
1.82	+/-0.030	1.819	>		V	
0.50	+/-0.030	.506	>		V	
11.63	+/-0.030	11.625	X		PRO W302	
81.00	+/-0.030	8.106	<		PR6	
1.350	+/-0.010	1.347	>		V	
2.25	+/-0.030	2.253	>		V	
1.81	+/-0.030	1.823	<		V	
3.750	+/-0.010	3.755	X		V	
1.250	+/-0.010	1.251	X		V	
8.90	+/-0.030	8.90	X		PRO W302	
0.400	+/-0.010	.402	X		V	
1.350	+/-0.010	1.345	>		V	
0.345	+/-0.010	.344	X		V	
1.875	+/-0.010	1.877	>		V	
6.73	+/-0.030	6.736	X		V	
2.90	+/-0.030	2.907	X		V	
6.98	+/-0.030	6.983	X		V	
1.38	+/-0.030	1.382	X		V	
8.44	+/-0.030	8.436	X		V	
0.040	+/-0.010	.049	X		V	

Measured by:	B	Audited by:	S	Preliminary Approval:	
Date:	11-4-25	Date:	11/04/26	Date:	

Rev	Date	Change	Revised by	Approved
A	09.05.11	New Issue	KJ	
B	10.02.18	Dimensions updated per Dwg Rev B	KJ	
C	10.12.21	Dimensions updated per Dwg Rev C	KJ	

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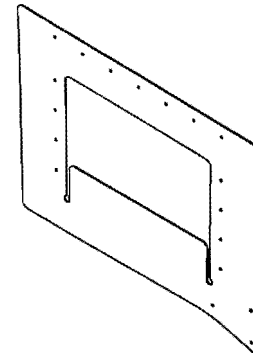
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____






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PL 11-04-21



RELEASED
2010-11-23

C	OFFSET TOP AND VERTICAL EDGES OF RECTANGULAR PERFORATING BY 0.250 OUTWARDS; UPDATE IDENTIFICATION REFERENCE		10.11.19
B	OFFSET TOP AND VERTICAL EDGES OF RECTANGULAR OPENING BY 0.250 INWARDS; ELIMINATE D3608, 17-3F; DELETED BENDING DETAILS. REASON: D3608-1/3 NOW SOLD TO CUSTOMERS UNBENT PER PAR909-087	MB	10.02.05
A	NEW ISSUE	MB	07.04.11
REV.	DESCRIPTION	BY	DATE
DESIGN	   	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV.
CHECKED		D3608	SHEET 1 OF
MFG. APPR.		TITLE	SCAL
APPROVED		DOUBLER	NT
DE APPR.			
DATE	10.11.19	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT OR REVISED OR SUPPLEMENTAL LAYOUT IS SUPPLIED FOR THE EXCLUSIVE CONSIDERATION THAT IT IS TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY OTHER MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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